

Date: Friday, 17/08/2007 11:19:35 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BLOWER MOTOR SUPPORT
<b>Job Number</b> : 34067	
<b>Estimate Number</b> : 12305	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D34715
<b>This Issue</b> : 17/08/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3471 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 28542	<b>Material</b> : N/A
<b>Written By</b> : <u>[Signature]</u>	<b>Due Date</b> : 11/09/2007 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>[Signature]</u> 08.20	
<b>Comment</b> : est rev A 06.03.02 New issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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**Comment:** Qty.: 0.1040 sf(s)/Unit Total: 0.4158 sf(s)  
 2024-T3 .063 sheet

110959 M102942

FF 07-09-06 <sup>10</sup>

4

2.0	SHEAR	SHEAR
-----	-------	-------



**Comment:** SHEAR  
 Cut part as per dwg D3471

FF 07-09-06 <sup>10</sup>

4

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 1-Deburr

FF 07-09-06 <sup>10</sup>

4

2-Bend as per dwg D3471

SB 07/09/10 (Y)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

EP 07/09/10 (84)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

07-09-11

(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/09/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:19:35 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 34067

Part Number: D34715

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*EP 07/09/11* (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 182

*EP 07/09/11* (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*EP 07/09/11* (4)

Job Completion



*U 07-09-11*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

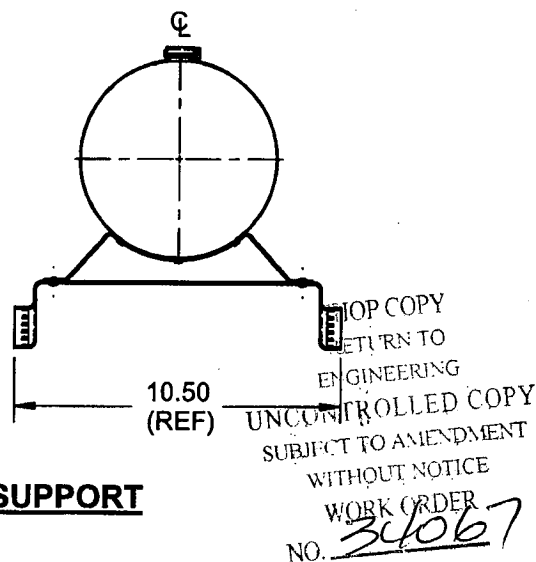
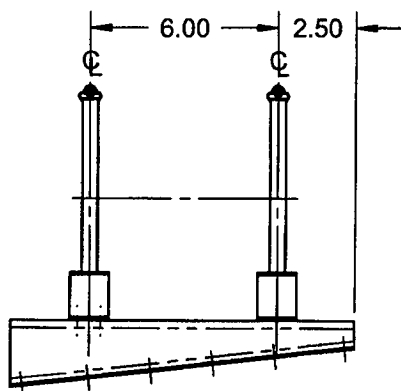
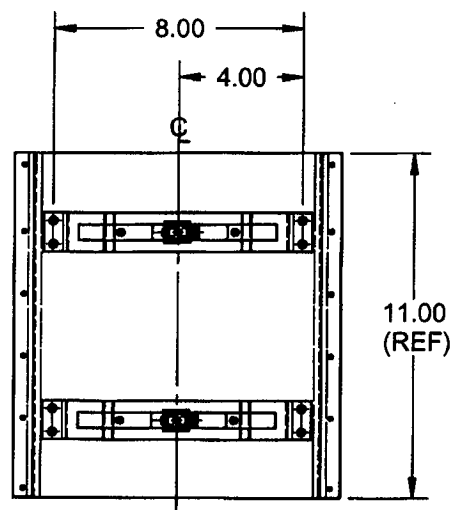
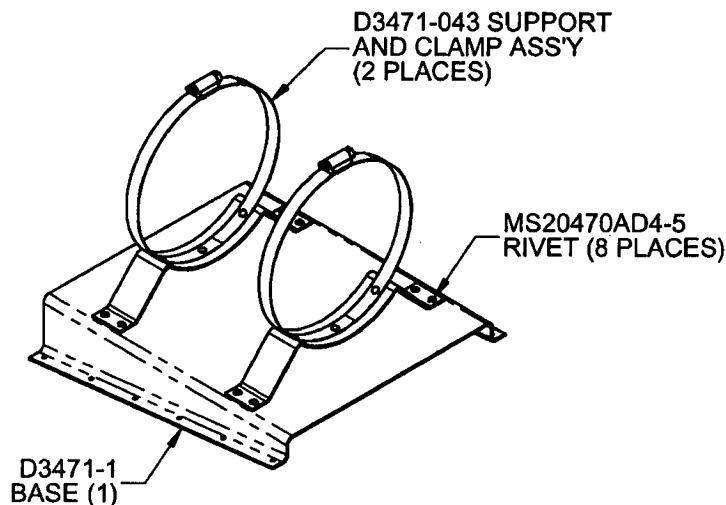
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3471</b>	REV. A SHEET 1 OF 5
DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	SCALE 1:6
A	05.12.21	NEW ISSUE	

06-04-03 *[Signature]***D3471-041 BLOWER MOTOR SUPPORT****NOTES:**

- 1) IDENTIFY WITH DART P/N D3471-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3471-041	BLOWER MOTOR SUPPORT
2	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-1	BASE
8	MS20470AD4-5	RIVET

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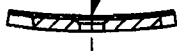
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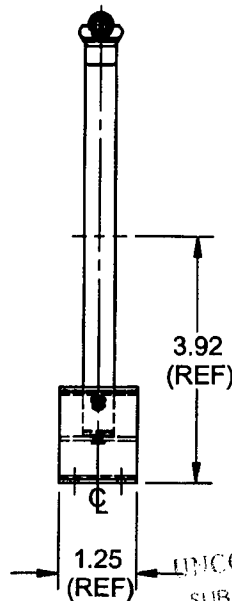
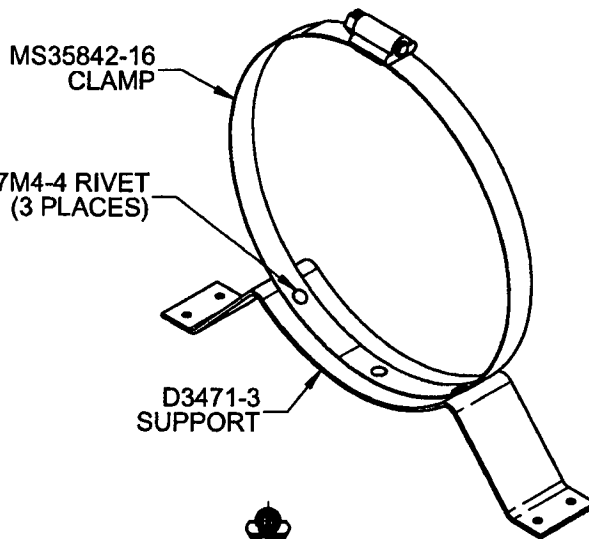
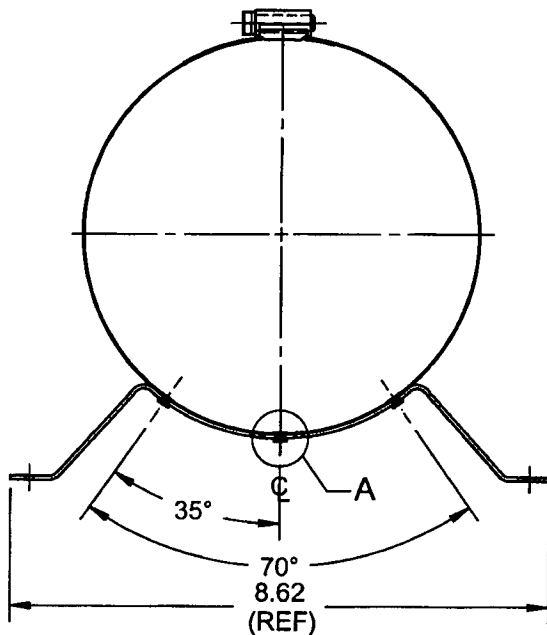
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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SHEET 2 OF 5 SCALE 1:3

06.04.03 *[Signature]*

LOCATE AND TRANSFER DRILL  
#30 ( $\phi 0.129$ ) THRU HOLE FROM  
D3471-3 TO MS35842-16 CLAMP  
AND C'SINK  $\phi 0.230 \times 100^\circ$   
(3 PLACES)



**DETAIL A: COUNTERSINK HOLES**  
(RIVET NOT SHOWN FOR CLARITY)  
SCALE 1:1



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### D3471-043 SUPPORT & CLAMP ASS'Y

#### NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

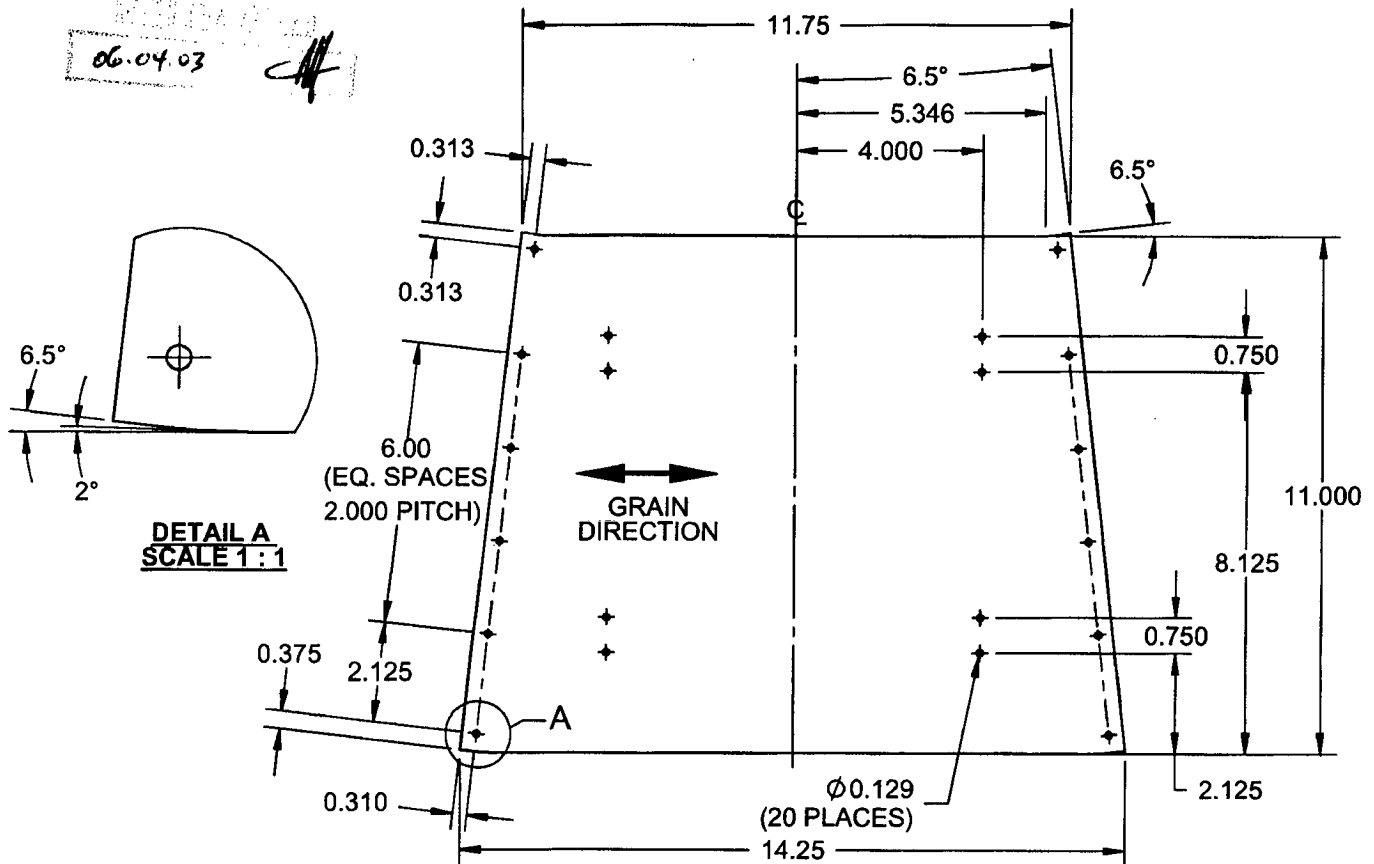
QTY -043	P/N	DESCRIPTION
X	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-3	SUPPORT
3	MS20427M-4	RIVET
1	MS35842-16	CLAMP

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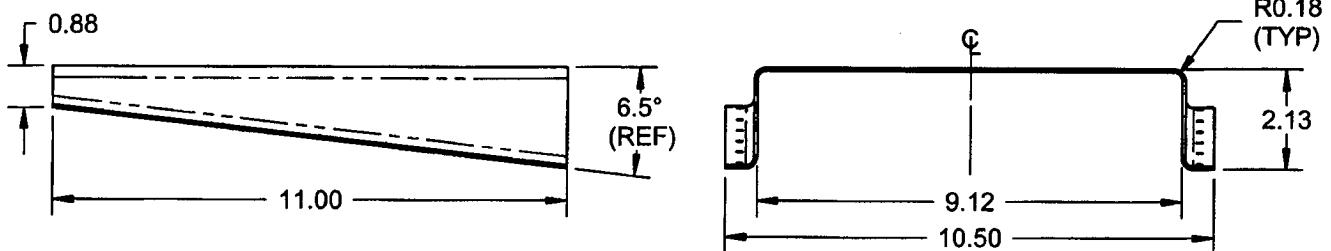
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DATE <b>05.12.21</b>	TITLE <b>BLOWER MOTOR SUPPORT</b>		SCALE 1:4



**D3471-1F BASE FLAT PATTERN**



**D3471-1 BASE BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

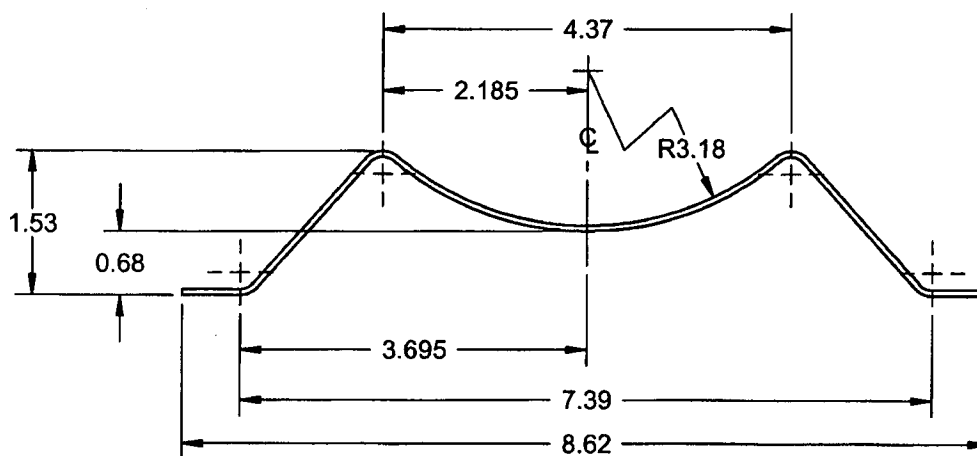
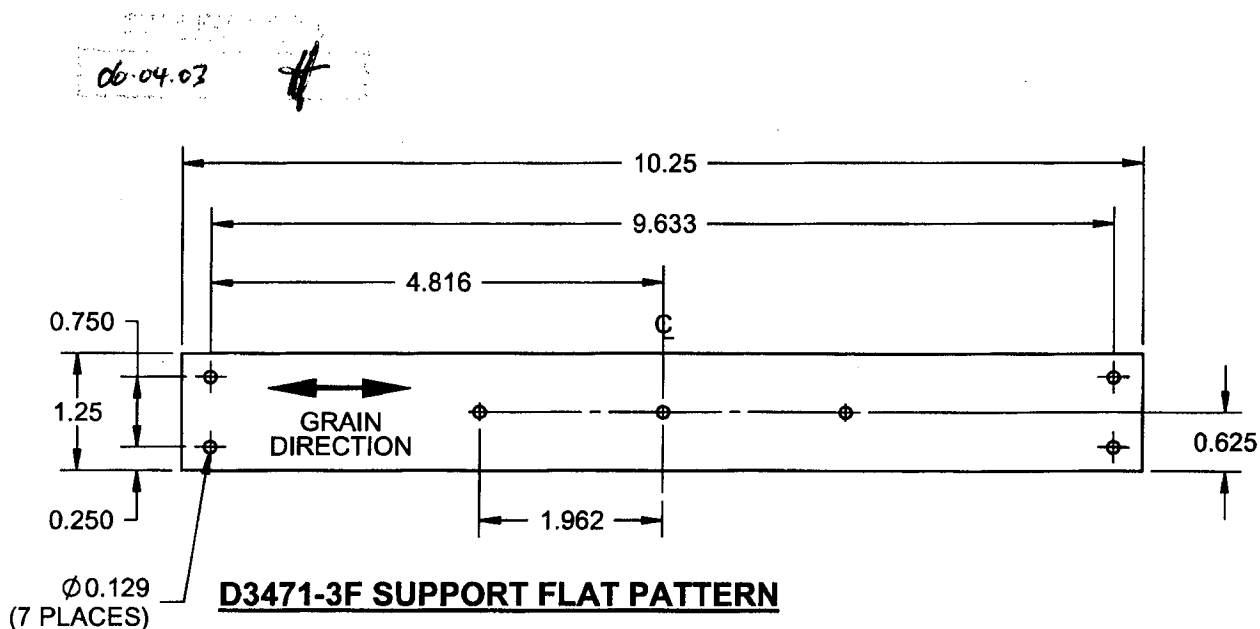
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DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	SHEET 4 OF 5 SCALE 1:2



### **D3471-3 SUPPORT BENDING DETAIL**

#### **NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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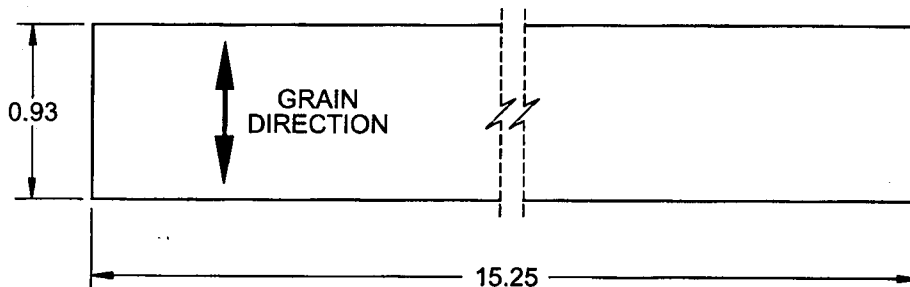
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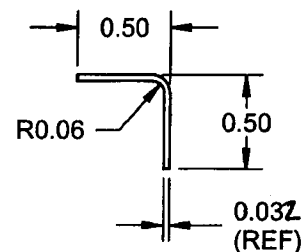


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DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	SCALE 1:1

06.04.03 *[Signature]*



**D3471-5F STIFFENER FLAT PATTERN**



**D3471-5 STIFFENER BENDING DETAIL**

**D3471-5 STIFFENER**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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